

Work Order ID 101450-2

\*101450\*

Page 1

May-13-13 10:29:56 AM

Item ID: D2230-3

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug

Start Date: 5/13/13

Start Qty: 300.00

\*300\*

Cust Item ID:

Required Date: 5/17/13

Req'd Qty: 300.00

\*300\*

Customer:

Reference:

Approvals:

Process Plan:

CD

Date: 13/05/13

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch:

Cut to meter.

CD 13/05/13

(300)

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio EA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2-deburr

P/O: F868

issue P/O to meter:

machine D2230REV.G

CD 13/05/13

300

# Work Order ID 101450

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Item ID: D2230-3

Accept

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Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug

Start Date: 5/13/13 Start Qty: 300.00

\*300\*

Cust Item ID:

Required Date: 5/17/13 Req'd Qty: 300.00

\*300\*

Customer:

Reference:

Run Start \*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

120 *see'd*

~~QC2-Inspect parts off machine FAI/FAIB~~

0.00

\*120\*

QC

Memo

0.00

Quality Control

*see'd + inspect  
attached cuf c to w/o*

130

*QC* Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

*SHD*

*BS 16*

*200  
can*

150

Chemical Conversion Coat per QSI005 4.1

0.00

\*150\*

HandFinish

Memo

0.00

Hand Finishing

*200 NB/BS-17*

# Work Order ID 101450

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May-13-13 10:29:56 AM

Item ID: D2230-3

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug

Start Date: 5/13/13 Start Qty: 300.00

\*300\*

Cust Item ID:

Required Date: 5/17/13 Req'd Qty: 300.00

\*300\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

\*160\*

QC

Memo

0.00

Quality Control

200X4M-f 13/05/23

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*170\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10-10  
3200F  
10-40

200X4M-f 13/05/23

180

QC3- Inspect Part Finish

0.00

\*180\*

QC

Memo

0.00

Quality Control

200c f 13/05/23

W125620



# Work Order ID 101450

\*101450\*

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May-13-13 10:29:56 AM

Item ID: D2230-3

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug

Start Date: 5/13/13 Start Qty: 300.00

\*300\*

Cust Item ID:

Required Date: 5/17/13 Req'd Qty: 300.00

\*300\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

190

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

ST469

200x

7.0.

13/05/23

*[Signature]*

\*190\*

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

QC

Memo

0.00

Quality Control

13/5/27 *[Signature]*

13-05-24

# Picklist Print

May-13-13 10:29:55 AM

Page 1

Work Order ID: 101450

Parent Item: D2230-3

Parent Item Name: Lug

Start Date: 5/13/13

Required Date: 5/17/13

Start Qty: 300.00

Required Qty: 300.00

Comments: IPP D00.05.18 Added inspection level 8, and removed P/O for powder  
coatEC IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED  
BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P LUG		Purchased	No				Each	0.0000		300			
D2423 Lug Extrusion		Manufactured	No			100	f	588.7400	0.0683	21.568421			

Location

Loc Qty

Loc Code

MAT006

383

43722

161.5

87953

221.5

Metec

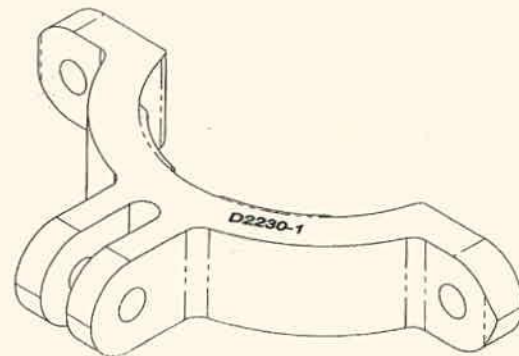
205.74

93551

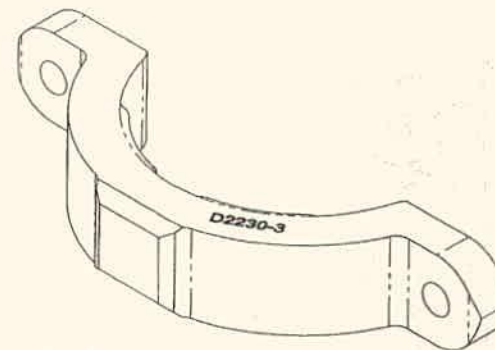
205.74

21.57

13/05/13 200  
13/05/13



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

CL 13/05/13  
W/O: 101450

RELEASED  
01/06/15



**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010  $\pm$  0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015  $\pm$  0.005.
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	09.12.13
E	RE-DESIGN	BW	05.01.04
D	RE-DESIGN	BW	05.01.04
C	RE-DESIGN	BW	04.03.00
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2230</b> <b>MOUNTING LUG</b> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.16	REV. G SHEET 1 OF 3 SCALE NTS	



**SECTION A-A D4-2**  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL

0.273  
REF

0.306

0.345

SYM ABOUT

1.200

FILLET EDGE  
PER SECTION  
A-A

MACHINE TO  
SIZE

D2230-1

R0.125  
REF

0.250

0.735  
REF

MACHINE TO  
SIZE

0.375

3.700

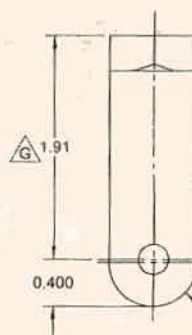
$\phi 0.257^{+0.005}_{-0.000}$

0.750

R0.38  
REF

SYM ABOUT

**D2230-1 MOUNTING LUG**



1.91

0.400

0.025  
REF

R0.38  
REF

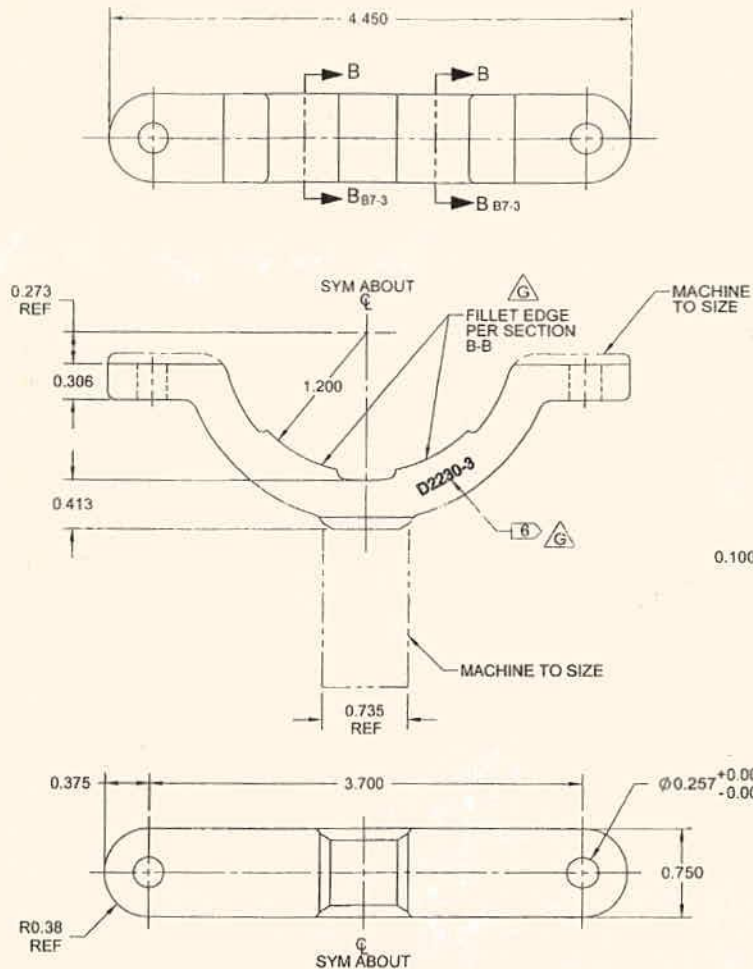
**RELEASED**  
07/06/75

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2230</b>	REV. G
MFG. APPR.		TITLE <b>MOUNTING LUG</b>	SHEET 2 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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**SECTION B-B** D4-3  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL



**D2230-3 MOUNTING LUG**

**RELEASED**  
09/06/2014

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: 19036  
Date: May 13, 2013  
Page: 1

<b>Sold to:</b>  <b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 19868	<b>Sold By:</b> Dewar, Eric
<b>Shipped By:</b> your truck	<b>Ship Date:</b> May 15, 2013

Description		Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3	Mounting Lug as per drawing D2230 REV.G , B101450	Each	300	200	100
D2230-3	Mounting Lug as per drawing D2230 REV.G, B101495	Each	300		300
D2230-1 B101834	Mounting Lug as per drawing D2230-1 REV.G,	Each	320	200	120
D3235-1 B101559	Mounting Lug as per drawing D3235-1 REV.A,	Each	200	100	100
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____			Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0  
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Lug	PO 19868
200	D2230-1	Lug	PO 19868
100	D3235-1	Lug	PO 19868

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, May 15, 2013